

Date: Tuesday, 10/24/2006 10:56:31 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	HELI UTILITY BASKET LH/RH 350/355
Job Number :	29127	Part Number :	D350607043
Estimate Number :	10208	Drawing Number :	D350-607 REV F P7-9
P.O. Number :	N/A	Project Number :	N/A
This Issue :	10/24/2006	Drawing Revision :	F
Prsht Rev. :	NC	Material :	N/A
First Issue :	N/A	Due Date :	11/15/2006
Previous Run :	28841	Qty:	1
Written By :		Um:	Each
Checked & Approved By :	KS 06 10 24		
Comment :	Est Rev: E as Per DSI9318 06-01-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-043 CHG003

KS 06 10 25

2.0	29127A	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D2989-041 B 29127A

3.0	29127B	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D2989-043 B 291270

4.0	29127C	BASKET BASE ASSEMBLY (350)
-----	--------	----------------------------



Comment: Sub-Component BASKET BASE ASSEMBLY (350)

D2221 B 29127C

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

6.0	NAS1515H4	Washer
-----	-----------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 NAS1515H4 WASHER M101428

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:31 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2022101

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

5 D2022-101 Spacer B25815

8.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2258-200 Label B28812

9.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass'y B28246

10.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment B28997

11.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring B25087

12.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing B28327

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2728-3

Label B22553

14.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2931

Bumper B21139

15.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-16A

Bolt 100564

16.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt 102380

17.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

7 AN4-22A

Bolt M17280

18.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

4 AN5-17A

Bolt M101532 (1) M102140 (3)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M102455

20.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416 Washer M102339

21.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M101237

22.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M102328

23.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer M100151

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet M101519

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) 101917

26.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

9 MS21042L4 Nut (or -4) 119185

27.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M102171

SAD 06:11:12

①

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



- Small support gusset with sika flex
- 29 (white) B: M102107



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

exp: 2007/02/01

SAD 06:11:12

①

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/13

①

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

31.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

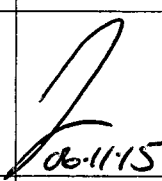
Pick: Packing Kit

Qty Part Number Description Batch

4 D2230-1 Lug B28281 V

06/11/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-11-15	28-0	Add: # sent support gusset with sikaflex AS shown. exp: <u>B #</u> permanent change made.					 06-11-15

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

B28245 ✓

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 *D2324-1

Strut Ass'y

B28062 ✓

34.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6000 f(s)/Unit Total: 0.6000 f(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2856-400-720 Abrasion Strip

B28258 ✓

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M102029 ✓

36.0

AN413A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN4-13A

Bolt

M102380 ✓

37.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total: 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

26 AN960JD416

Washer

M102339 ✓

Boe 11/13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI UTILITY BASKET LH/RH 350/355

Job Number: 29127

Part Number: D350607043

Job Number:



Seq. #:

Machine Or Operation:

Description :

38.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

119185 ✓

10/26/13

39.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

40.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-043

Location:

1200E

10/26/14 (1)

41.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



10/26/14

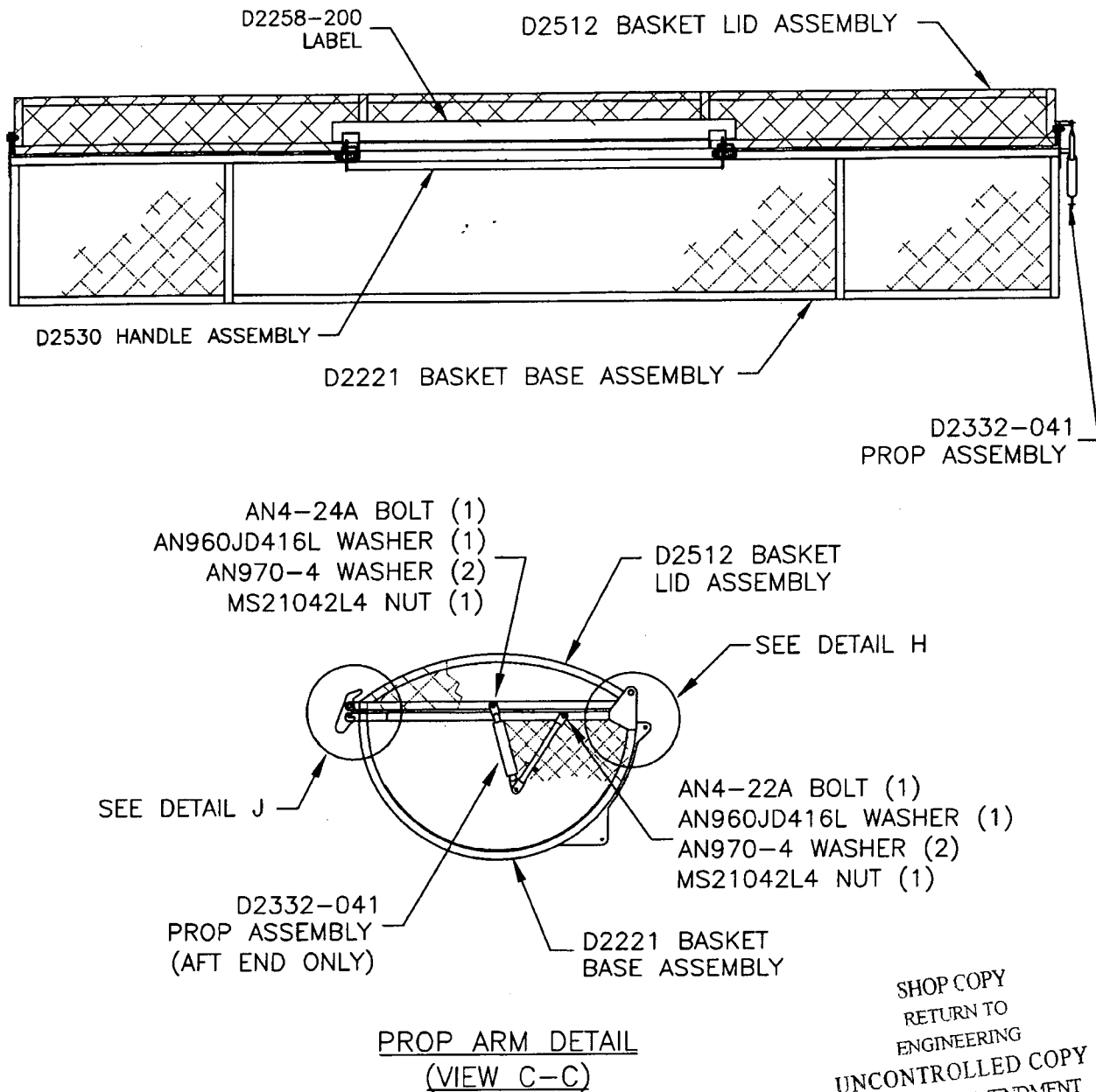
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

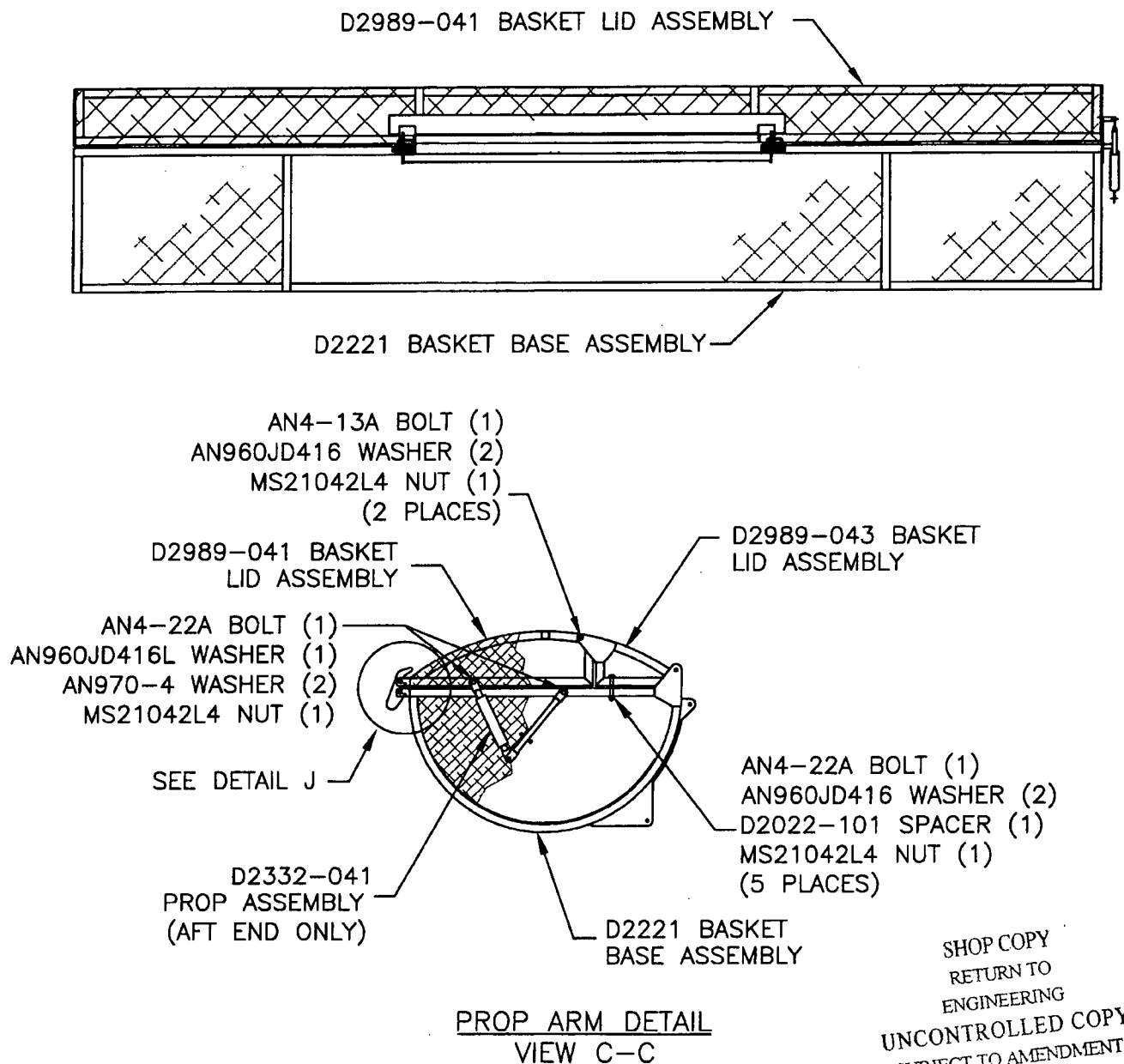


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29127

Figure 4 – Basket Replacement Parts
(D350-607-041 Heli-Utility-Basket™)

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Revision: F
Date: 03.01.17

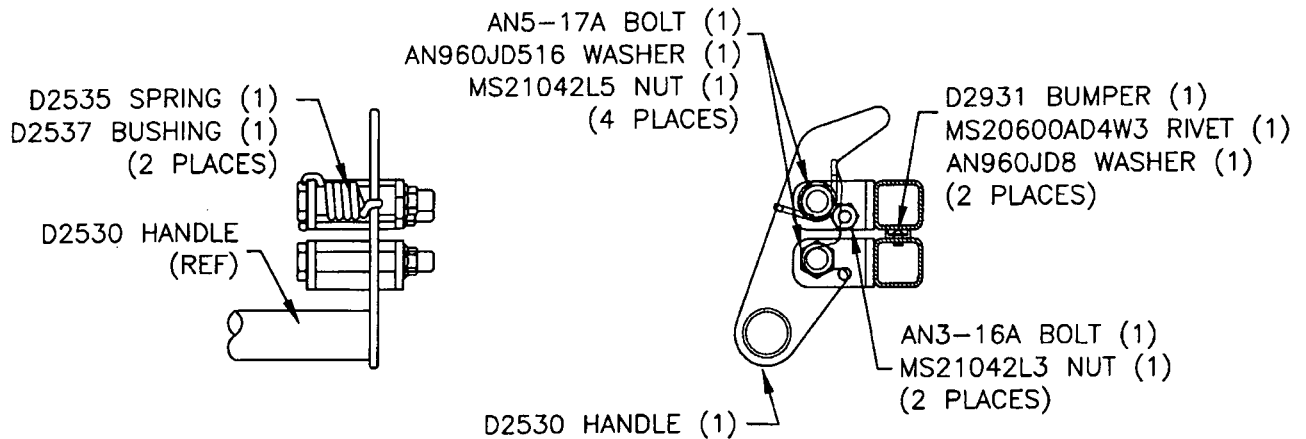


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29127

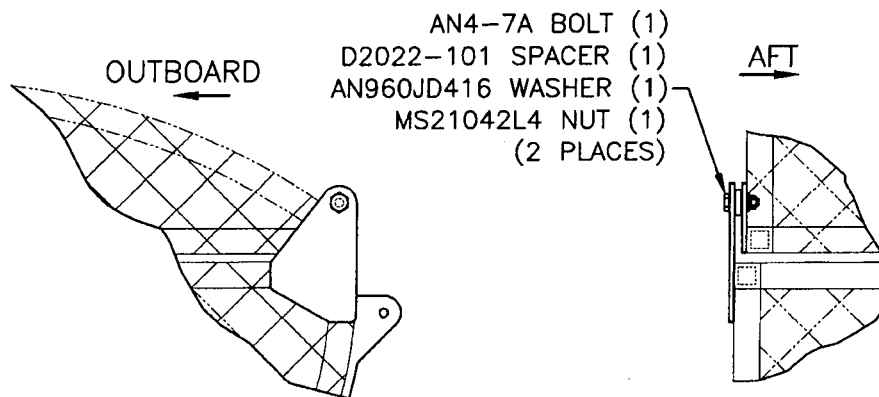
Figure 5- Basket Replacement Parts
(D350-607-043 Heli-Utility-Basket™)

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Revision: **F**
Date: 03.01.17



DETAIL J:
HANDLE WELDMENT



HINGE DETAIL
END VIEW, LOOKING AFT
OTHER END OPPOSITE

HINGE DETAIL
SIDE VIEW, LOOKING OUTBOARD.
OTHER END OPPOSITE

DETAIL H:
HINGE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29127

Figure 6 – Basket Replacement Parts

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OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Revision: **F**
Date: 03.01.17

Date: Tuesday, 10/24/2006 10:56:45 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASSEMBLY
Job Number	: 29127A		
Estimate Number	: 10206		
P.O. Number	: N/A	Part Number	: D2989041
This Issue	: 10/24/2006 S.O. No. : N/A	Drawing Number	: D2989 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 28841A	Material	: N/A
Written By	: <u>JA 061024</u>	Due Date	: 11/15/2006 Qty: 1 Um: Each
Checked & Approved By	: <u>JA 061024</u>		
Comment	: Est Rev: Removed D2989-043 05-11-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty.(1) D3166-3 Batch: B28525

PD 06-10-26 (1)

2.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2581 Mounting Brackets B27587

PD 06-10-26 (1)

3.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2327-3 Bushing B28073

PD 06-10-26 (1)

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part number Description Batch

1 D2506 Label Plate B27217

PD 06-10-26 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:45 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 29127A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 15.0000 sf(s)/Unit Total: 15.0000 sf(s)

Pick:

Qty Part number Description Batch

15sf M304EX0.75-16F Expanded Metal

M102394

PD 06-11-03 1

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 31.7709 f(s)/Unit Total: 31.7709 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: M102357

PD 06-10-25 1

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

2-Drill holes in tubing as D2989-041 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-041 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

5-Drill Ø0.257" hole as D2989-041 per Dwg D2989 Identify as D2989-041

PD 06-11-6 1

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

DD 06/11/07

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DD 06/11/07

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Y F.C. 06/11/00
M101575

X1

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: PAR #: Fault Category: NCR: Yes ☐ No ☒ DQA: PD Date: 06/14/15
 QA: N/C Closed: Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:46 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 29127A

Part Number: D2989041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Wing walk D2989-041 as per Dwg D2989 and QSI 005 4.4

Spray Paint Black: 101933

Wing Walk: 102098

Y/a.m. 06/11/10 x 1

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

FC 06 11 11 @

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
06/11/15

Job Completion



C 06/11/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 *[Signature]*

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

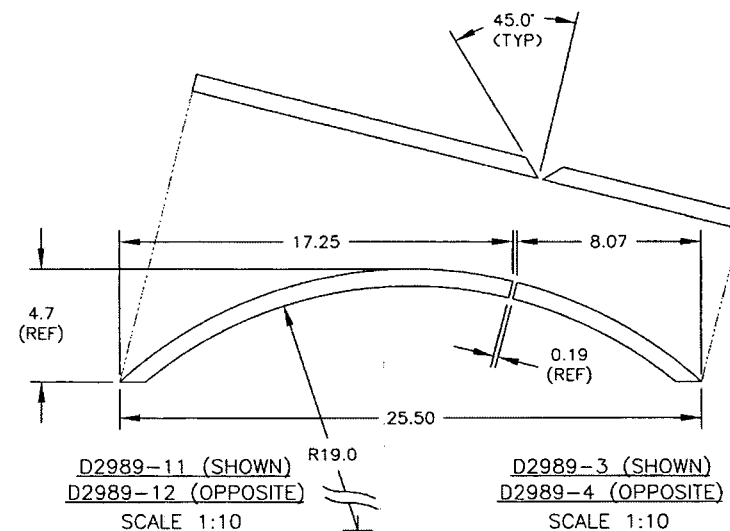
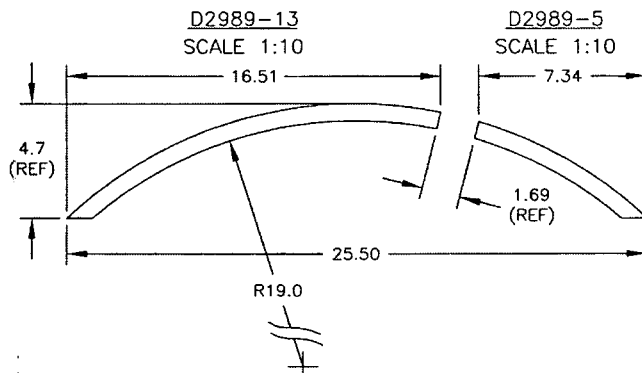
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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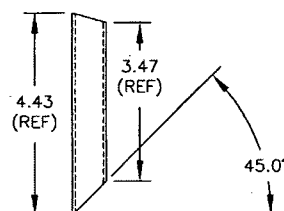
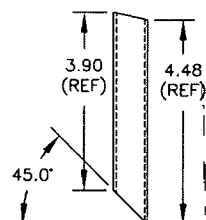
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NO. 29127A

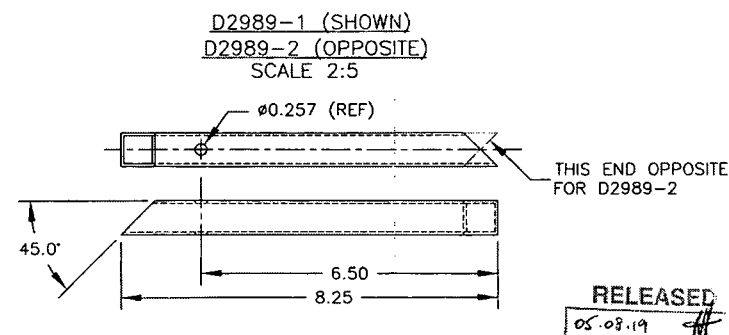
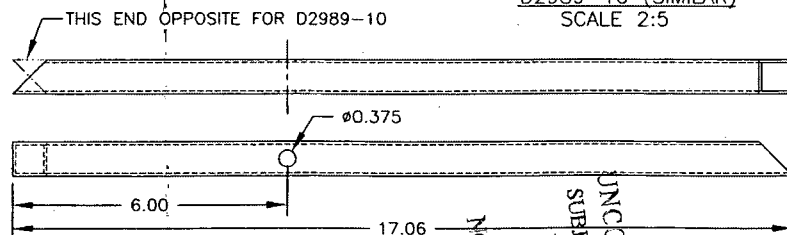


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

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WORK ORDER
NO. 29127A

Date: Tuesday, 10/24/2006 10:56:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 29127B	
Estimate Number : 10207	
P.O. Number : <i>N/A</i>	Part Number : D2989043
This Issue : 10/24/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2989 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 28841B	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/15/2006 Qty: 1 Um: Each
Checked & Approved By : <i>[Signature]</i> 061024	
Comment : Est Rev: Removed D2989-041 05-11-03 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3182-1 Hinge *B28315**PD**06-10-26 (1)*

2.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D3442-3 Shim *B23545**PD**06-10-26 (1)*

3.0	M304EX07516F	Expanded Metal Flat Stai
-----	--------------	--------------------------



Comment: Qty.: 8.0000 sf(s)/Unit Total : 8.0000 sf(s)

Pick:

Qty Part number Description Batch

8sf M304EX0.75-16F Expanded Metal *M102394**PD**06-10-26 (1)*

4.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 17.6400 f(s)/Unit Total : 17.6400 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SStubing.

Batch: *M102137**PD**06-10-25 (1)*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/11/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:56:55 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 29127B

Part Number: D2989043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut (4) D2236-1 From D3166-3 As Per Dwg D2989

Note: D2989-3/-4 On -041 Bom

2-Drill holes in tubing as D2989-043 per Dwg D2989

3-Deburr and remove all markings on material

4-Weld as per Dwg D2989 and D2989-043 Assembly using Welding Table and corner Jig. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid

PD 06-11-06 ①

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/11/07

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06/11/07

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M101575

Y/L 06/11/10 X1

1-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

FC 06 11 11 ①

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/15 ①

Job Completion



C Loc 11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2989	REV. B SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	00.10.27	NEW ISSUE	
B	05.06.07	ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS	

RELEASED

05-08-19 H

PARTS LIST:

Qty -041	Qty -043	Part Number	Description
X		D2989-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D2989-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
2	2	D2989-17	STRUT (96.00" LONG)
2		D2989-19	STRUT (31.19" LONG)
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
	2	D3442-3	SHIM

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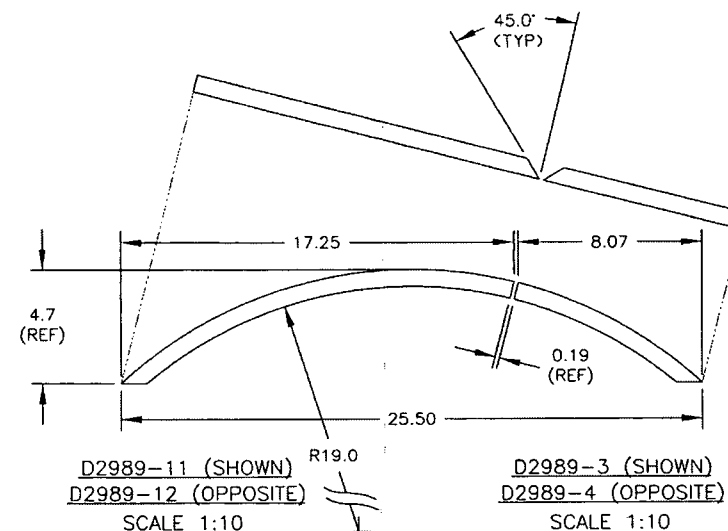
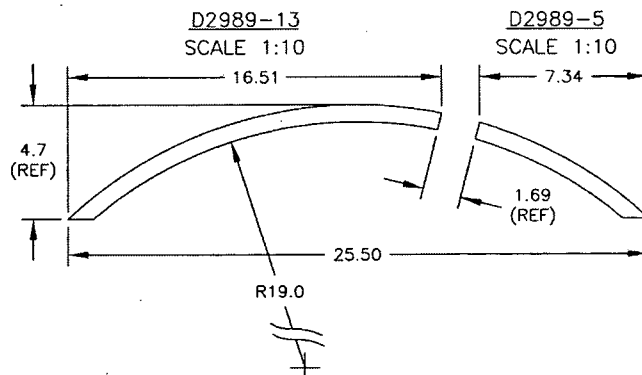
NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING
D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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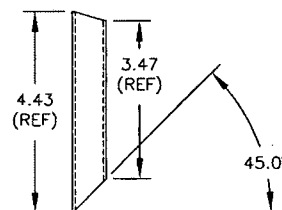
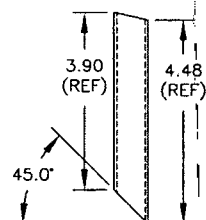
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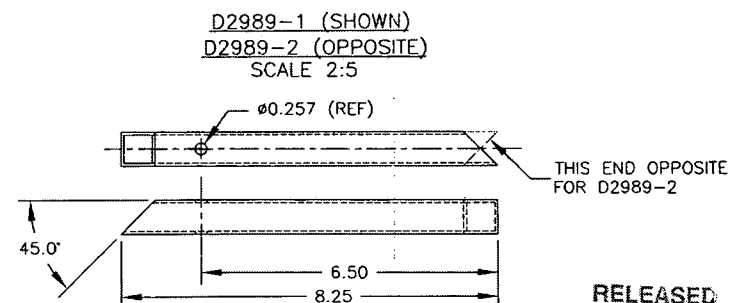
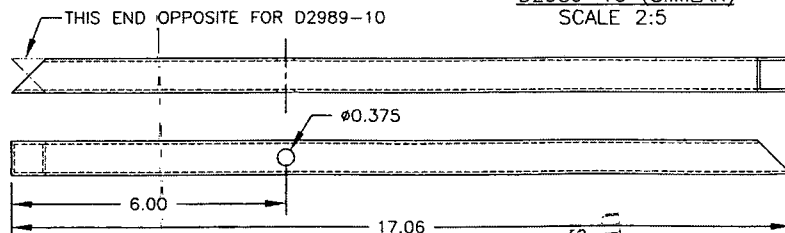


D2989-15
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY. CUT TO FIT ASSEMBLY)

D2989-7
SCALE 2:5
(DIMENSIONS LISTED AS REFERENCE ONLY. CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)
D2989-10 (SIMILAR)
SCALE 2:5



RELEASED
05-08-19

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DESIGN DS	DRAWN BY PH	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07	TITLE BASKET LID ASSEMBLY	SCALE 1:10	

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WORK ORDER
212713

Date: Tuesday, 10/24/2006 10:57:12 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASSEMBLY (350)
Job Number : 29127C	
Estimate Number : 10189	
P.O. Number : N/A	Part Number : D2221
This Issue : 10/24/2006 S.O. No. : N/A	Drawing Number : D2221/D2235
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY	Drawing Revision : F/B1
Previous Run : 28841C	Material : N/A
Written By : <u> </u>	Due Date : 11/15/2006 Qty: 1 Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev:J 05.09.02 Added D3442-1KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3166-1 RIB B28850

PD 06-11-01 ①

2.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge bracket B24527

PD 06-11-01 ①

3.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2325 Support Gusset B28313

PD 06-11-01 ①

4.0	D23273	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2327-3 Bushing B28073

PD 06-11-01 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:57:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 29127C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2581 Mounting Bracket B21587

PD

06-11-01

①

6.0

D34421

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3442-1 Shim B28322

PD

06-11-01

①

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 41.6745 sf(s)/Unit Total: 41.6745 sf(s)

Pick:

Qty Part Number Description Batch

39.69 sf M304EX0.75-16F Expanded Metal M102394

PD

06-11-03

①

8.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 29.4000 f(s)/Unit Total: 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SS tubing

Batch: M102157

PD

06-11-01

①

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

PD

06-11-06

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 02/10/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/24/2006 10:57:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 29127C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

11/06/11/07

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11/06/11/07

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M101575

4/9am 06/11/10 x1

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FE 06 11 11 (1)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SP06/11/15

Job Completion



C206/11/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

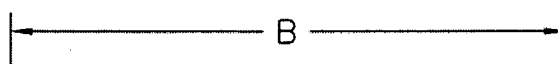
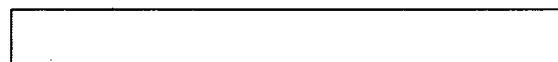
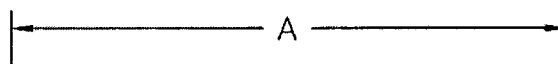
DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D2221	REV. F SHEET 1 OF 3
DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
C	95.11.21	SEPARATE BASKET AND LID	
D	96.06.21	CHANGE LATCH	
E	01.04.19	CHANGE HINGE	
F	05.06.07	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

RELEASED

05.08.19 H

PARTS LIST FOR D2221 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2221-1	2	—	96.00	RIB
D2221-3	2	—	25.50	RIB
D2221-5	2	18.88	—	RIB
D2221-7	1	55.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-1	2	N/A	N/A	SHIM



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WITHOUT NOTICE
WORK ORDER
NO. 29127C

D2221-1/-3/-5/-7

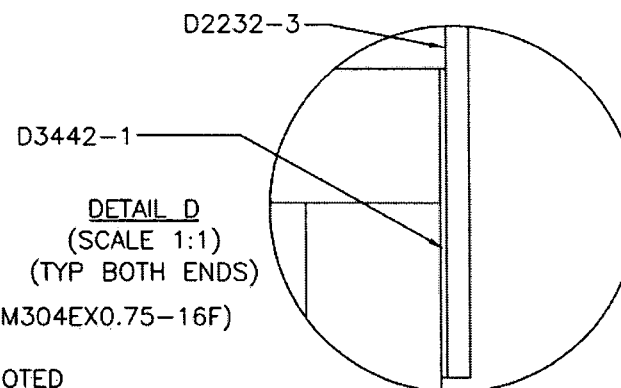
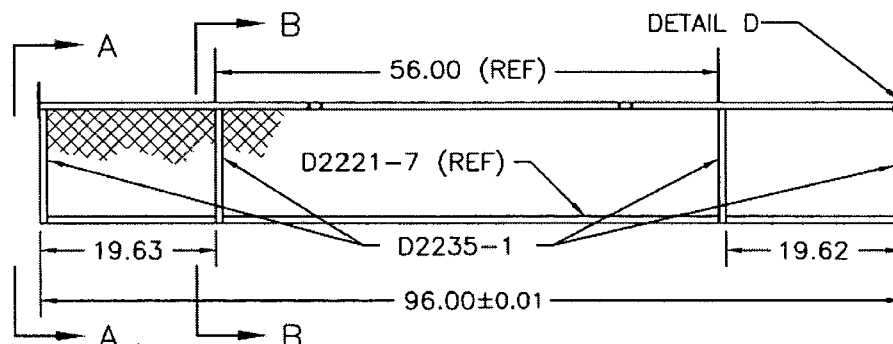
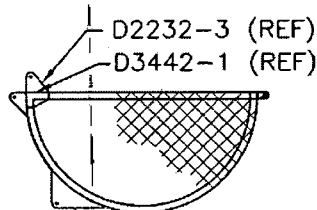
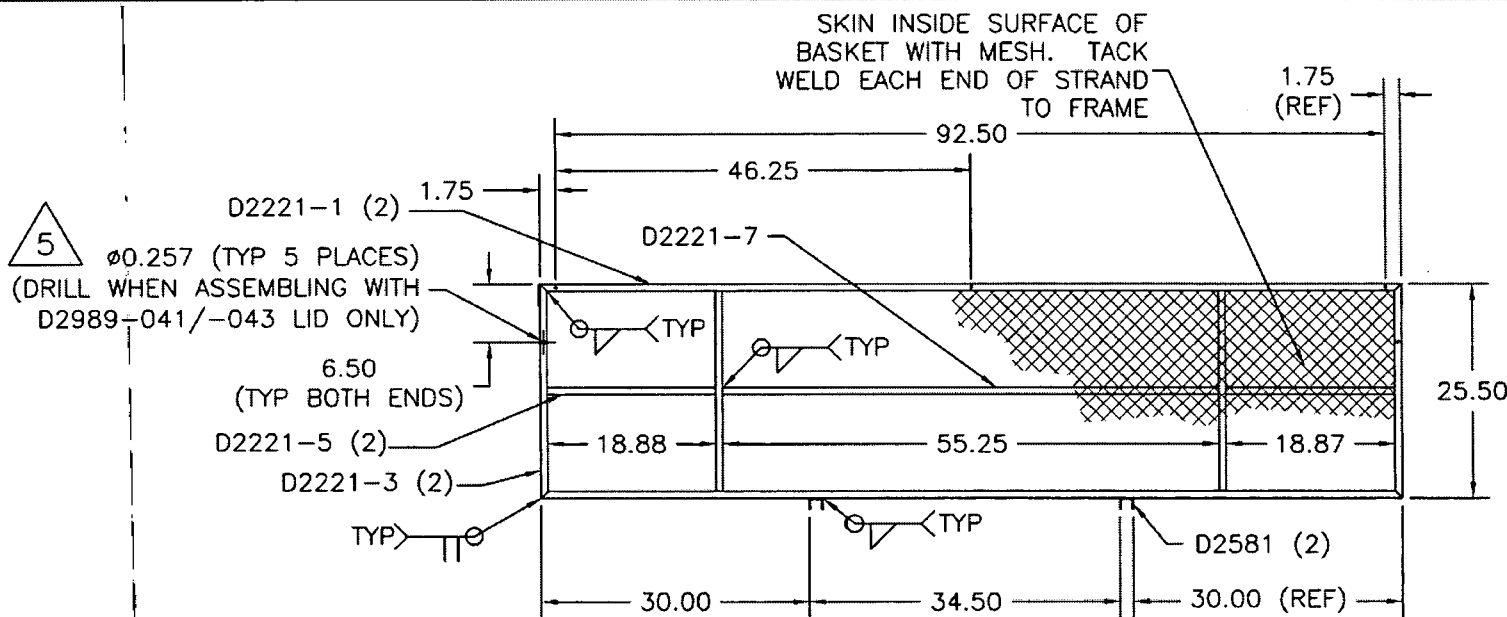
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI-018-UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL $\phi 0.257$ HOLES ONLY WHEN ASSEMBLING D2221 BASE WITH
D2989-041/-043 BASKET LID

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DATE	05.06.07	TITLE	D2221	BASKET BASE ASSEMBLY (350)	SHEET 2 OF 3
					SCALE 1:20



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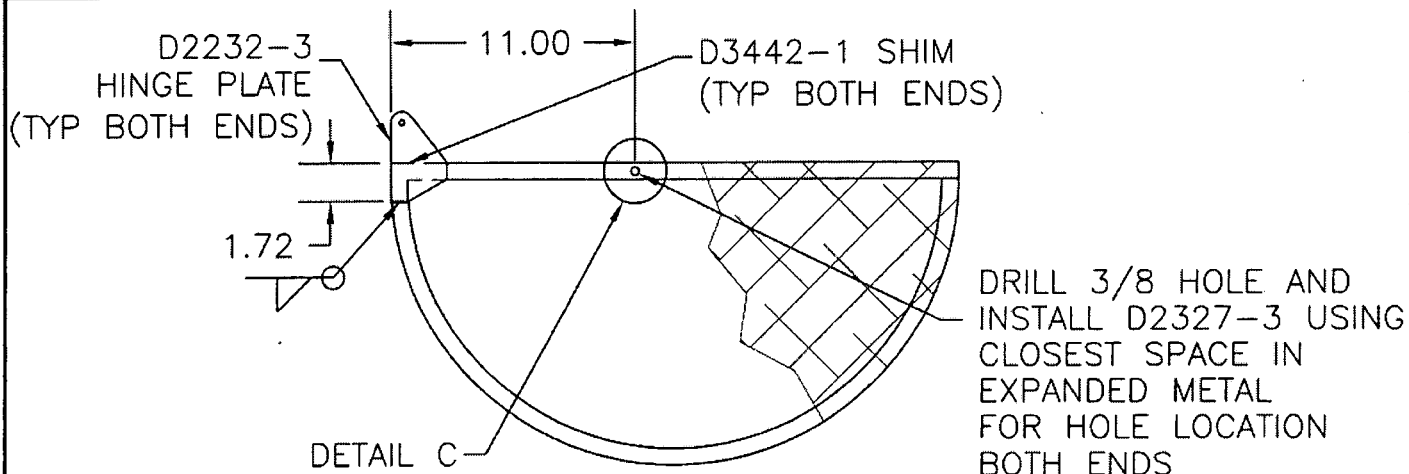
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D2221 BASKET BASE ASSEMBLY

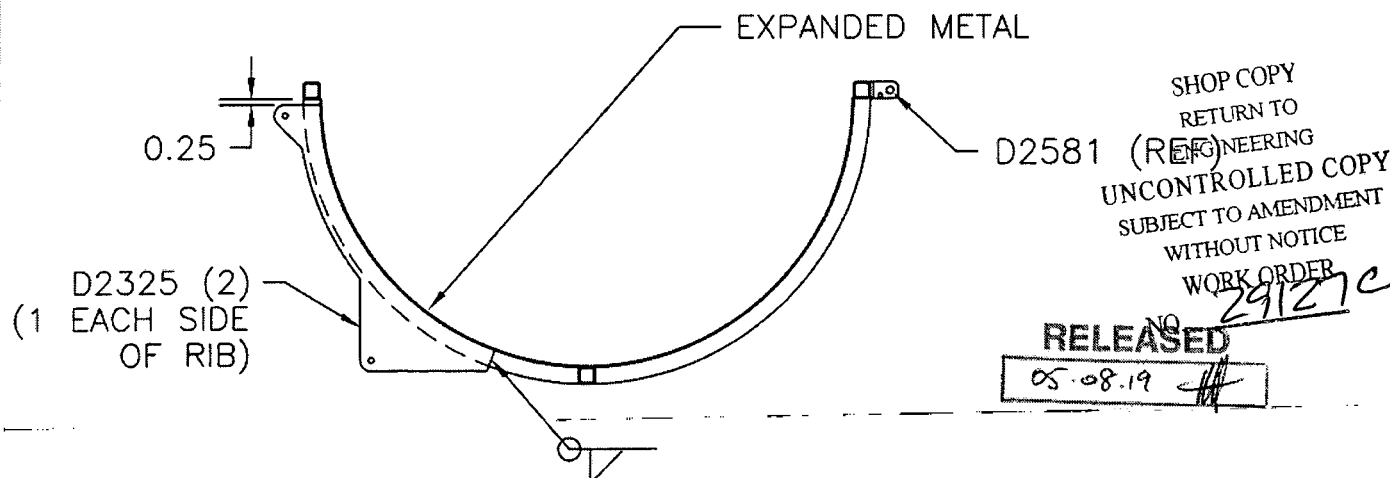
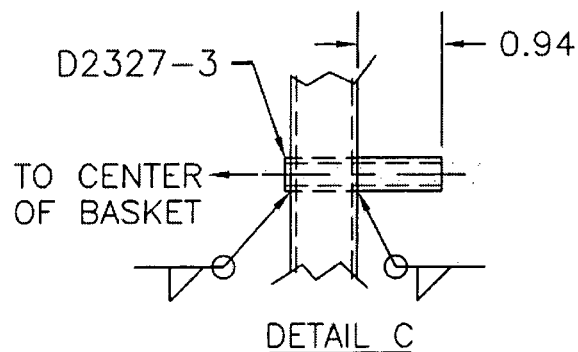
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF DART SPEC M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3



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DATE 05.06.07		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SECTION A-A SAME BOTH END RIBS



SECTION B-B SAME BOTH CENTER RIBS

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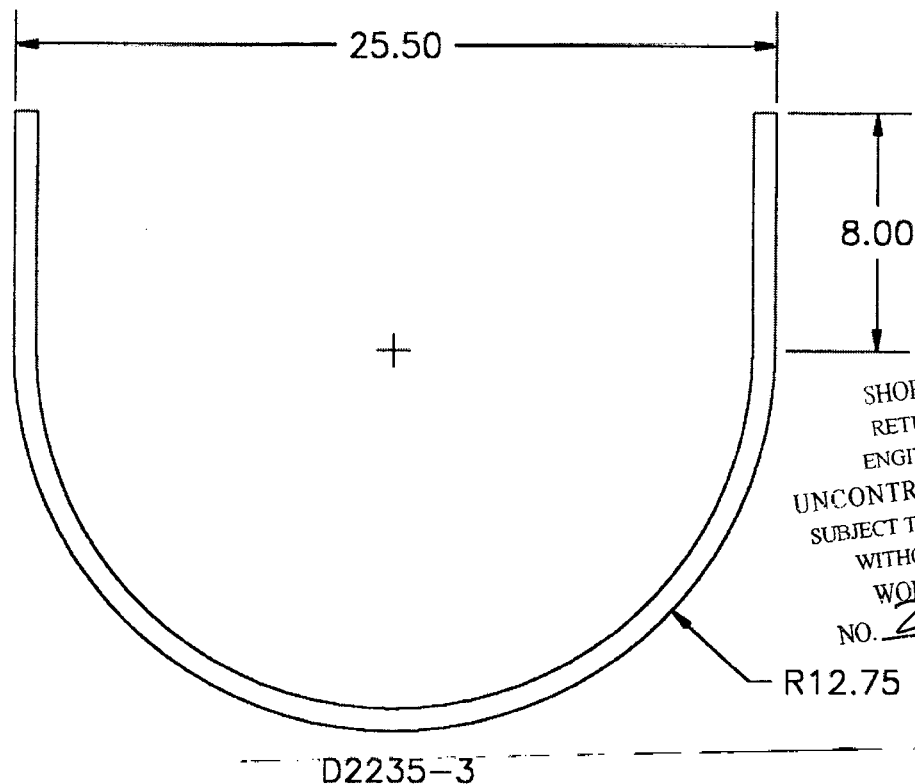
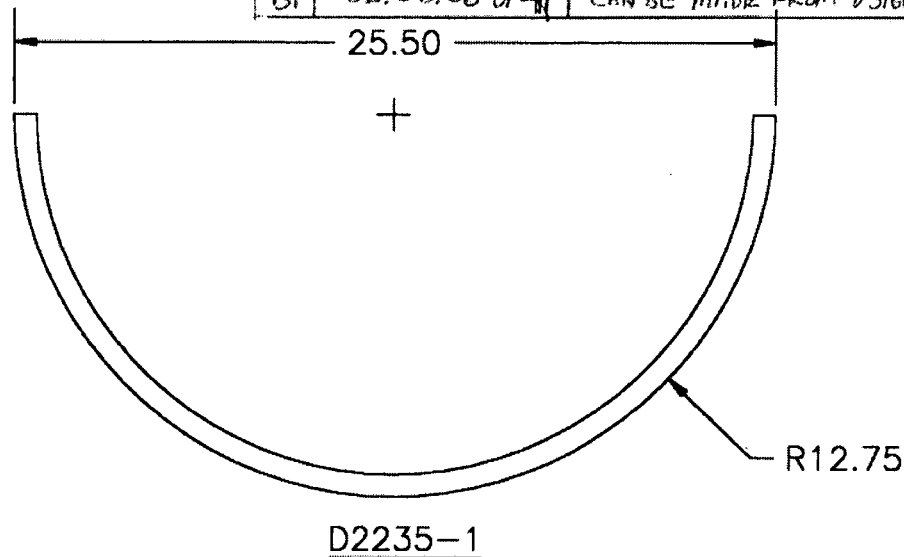
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B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED <i>BW</i>	APPROVED <i>BW</i>	D2235	SHEET 1 OF 1
DATE	TITLE		SCALE
94:12:16	BASKET RIBS		
BI	02.08.06 <i>UP</i>	CAN BE MADE FROM D3166-1	

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MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.